PROJECT TITLE : SPECIFICATIONS AND PROCESS ASSURANCE

Period Covered : 23.5. - 25.6.1980
Report Written By : C. Flury and T. Bel
Report Approved By: J.B. Boder

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0. Specifications - General

- The edition number 3 of the PME guidelines for manufacturing and material specifications, which had been discussed during the QC PME meeting of April, 1980, have been distributed with an accompaning letter of J.B. Boder.

1. Specifications Fabriques de Tabac Réunies SA

- Products with new numbers printed on packs:
  - Brunette Extra BRE/BRS passed from 7/0,6 to 6/0,5 mg.
  - Brunette Carrée BRC passed from 23 to 21 mg

- The following new specs have been established:
  - Ambassador packing spec MAA 059, for sale in Tunisia (Air Tunis)
  - Filter making specs for a combined filter (black/white, non-porous, 120 mm) to be produced for sale to PM Nigeria.

- The RTDs resistances to draw have been adapted for the three porous combined filters:
  - MAA 108 mm 34.7108 from 450 to 420 mm WG
  - MAK 120 mm 34.7220 " 480 " 420 "
  - MPH 100 mm 34.7001 " 290 " 270 "

- The cigarette paper quality 006, WP 60, has been replaced by quality 036, W 100, on the cigarette MAG Ambassador Extra Mild KS. The objective is to reduce the numbers.

- Packing version Marlboro MLF 029, sale Sweden, has been re-issued, as the launch of the Marlboro King Size cigarette in Hinge Lid pack has been postponed.

- The former metallic packet tear tape, used on PMI Ph. Morris International, has been replaced by a thermogluing tape.

- Several packing specs for products to be sold in Switzerland have been modified: As from 1.10.1980,

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the selling price will be 10 cents higher, and at the same time, a "Warning..." will be printed on all packs.

2. Specifications INTERTABA S.p.A. Zola Predosa

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3. Specifications PM Holland

- The processing specs for blend NPK North Pole King Size have been modified. A menthol content of plus 10 % will be applied (see product modification 28.4.80).

4. Specifications PM Germany

- The manufacturing specifications for MLB Marlboro King Size, in Hinge Lid pack, produced under contract at Austria Tabakwerke Berlin on behalf of PMG Berlin, have been issued.

- All specs for PMG Berlin have been reviewed.

- The filter length of BSL Bond Street Mild, MLN Marlboro Menthol KS, and PMI Ph. Morris International, has been increased from 20 to 21 mm

5. Specifications WELTAB SA

- The manufacturing specs for the products manufactured under contract with Jubilé, on behalf of WELTAB SA, are still outstanding.

- Provisional specs have been issued for project Merit Boost Programme UK (Merit Filter KS, Great Britain) Cigarette MER 09, brand code MER 152.

- Upon PME Development request, the RTD of the 120 mm filter, used on Marlboro KS Great Britain, has been increased from 375 to 410 mm WG.

- On cigarette MAC Ambassador Extra Mild KS, a tipping paper with 6 instead of 4 perforation lines is used, to reduce the numbers.

6. Specifications PM London

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7. Specifications Licensees

- Italy:
  The processing and cigarette making specs have been modified in view of the final step of Esther addition to the blends Mercedes (7,5 %), Ambassador (6,875 %), and Marlboro (6,666 %).

- DDR:
  Project specs have been prepared for the manufacture of a MPH Multifilter 100s cigarette in Nordhausen.

- Great Britain:
  The specs file of Manchester Tobacco Co. has been completed by LAG Lark King Size, in Hinge Lid pack.

- Nigeria:
  Project specs for project York, an Multifilter King Size cigarette, have been prepared.

8. Material Specifications

- After an interruption of several months, the 12th QC and MPP PME coordination meeting took place in Lausanne, on 12.6.1980.

- Following the requests of all QC and Purchasing managers of the production centers, a letter has been addressed to A. Peier, MPP PME, so that the attachment of correct and coloured identification slips to the cores of the cigarette paper and filter paper bobbins will be coordinated and organized.

9. PME Standard Recipes

- A letter with different recommendations concerning the list of ingredients and the PME material numbers for ingredients has been addressed to all QC managers, on 17.6.1980.

10. Specifications on EDP

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11. Process Assurance

11.1 AccuRay

A letter has been addressed to all QC managers, explaining the present situation and the reasons for not having adopted the AR limits fixed during the QC PME meeting, with immediate effect. New proposals have been made by QC FTR, in agreement with FTR's production management. These limits will be presented to the QC managers of the other production centers.

11.2 Non-tobacco Material Weights in Specifications

Some of the production centers have not yet carried out the test required to determine a PME standard specification regarding the weight of the glue on the cigarette seam.

The next process assurance method to be prepared will refer to the weight of the glue on the tipping paper. However, a feasability test will first have to be carried out by FTR.

11.3 Diameters of Filters and Cigarettes

A discussion with PME Product Coordination will take place in Lausanne on 30.6.1980 to define the details of the planned standardisation of cigarette diameters to 7,95 mm, on European level. The programme will also include the cigarettes with logotype-printed tipping papers.

11.4 Dilution

The inventory on dilution results for all European fully and semi-diluted MLFs Marlboro Filter cigarettes is not yet complete (other priorities). The report should be concluded by the end of July, 1980.

11.5 Foil Mentholating

The three methods referring to the foil mentholating process have been distributed to all QC managers:

a) Mentholating of inner aluminium foil	No 7.15
b) Storage of mentholated aluminium foil	No 7.16
c) Cigarettes with foil mentholation	No 7.17

11.6 Burley Treatment

As soon as the information from PM Holland, regarding

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the Bergen op Zoom Burley dryer, will be available, a final report will be prepared and distributed.

During our visit to PMG Berlin, some information could also be collected regarding the Proctor & Schwartz equipment to be erected in their new processing department.

11.7 Kitchen and Pre- and After-cutting Solutions

The final report will be edited after the visit to PMG Munich which is planned for beginning July. All information from the other production centers is available.

11.8 Production of Starch Glue

A final report will be written after the visit to PMG Munich, beginning July.

11.9 Tobacco Weights

This is a new study which has the objective of comparing the effective tobacco weights in the different production centers for the cigarettes MLF - MLK - MLB - MER- MPH. The extreme deviations per machine and the light weight rejects will be included in the study, which will cover the five first months of 1980. - All production centers have been contacted and their results are awaited, so that the presentation can be terminated until mid-July, 1980.

11.10 New Processing Departments in PMG Berlin and PMH Bergen op Zoom

A detailed programme regarding the quality control check points will be prepared in cooperation with PMG aud MPH. Our office has been charged to coordinate between the two project teams which will be summoned in the two production centers. A complete test programme will have to be presented by end September, 1980.

T. Bel C. Flury

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